



DESIGN <i>MS</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>MS</i>	APPROVED <i>KE</i>	DRAWING NO. D2650	REV. C SHEET 1 OF 7
DATE 97.10.29		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
C1	<i>#</i> 01.08.20	$\phi 0.640$ WAS $\phi 0.625$ (-54-7)	

RELEASED
97/11/06 DS

EFFECTIVE	DEOS
9098 98/01/28 DS	9136 99.02.26 DS
9153 99/04/28 DS	9163 99.09.16 DS

SUPERCEDED BY

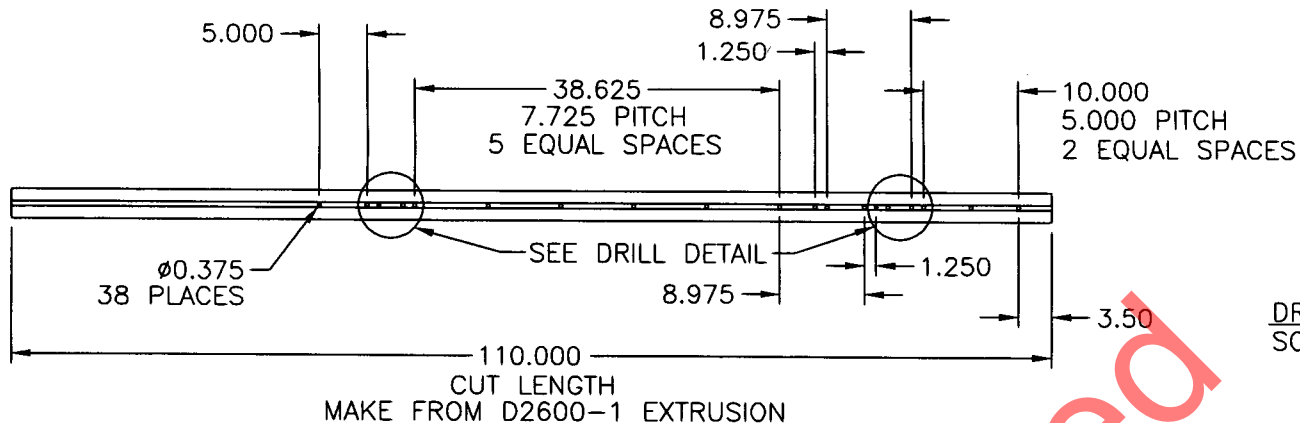
Rev. D 04.06.23 *MS*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
*	*	*	*	D2600-1	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
19	20	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
42	44	54	60	ALS4-1032-130 or AKS7-1032-130	INSERT
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	BOLT

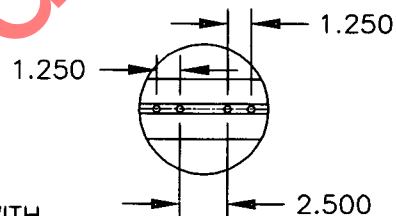
* SEE DRAWING D2650 FOR CUT LENGTHS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELDING TO BE DONE PER DART QSI 004

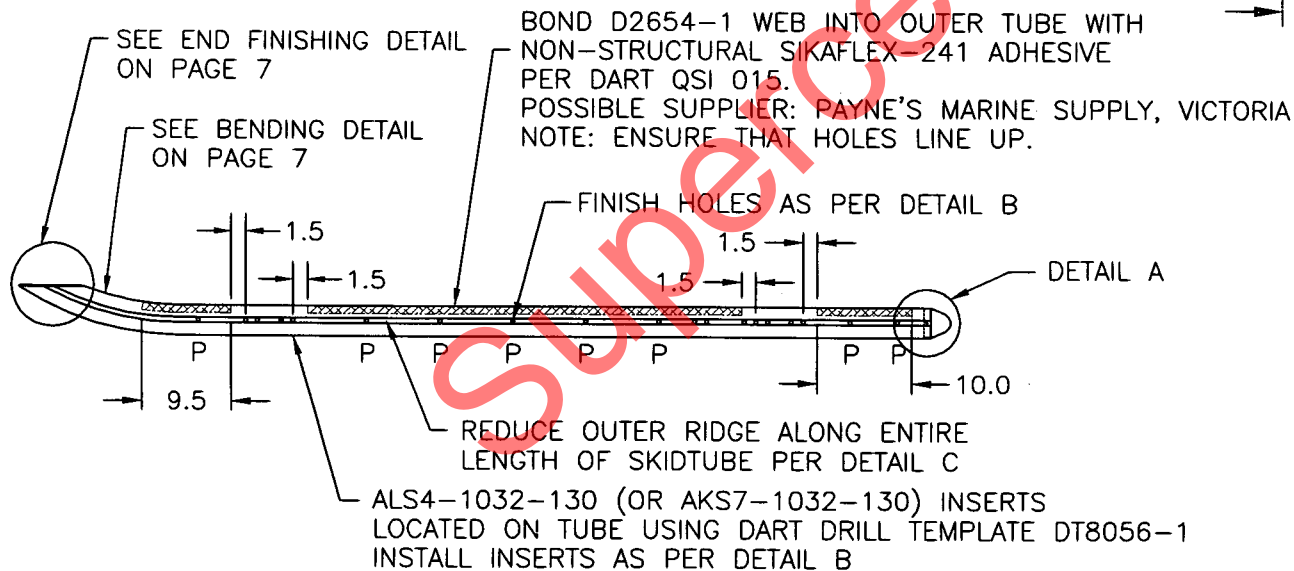
D2650-1 DRILLING DETAIL



DRILL DETAIL
SCALE 1:10



D2650-1 FINISHING DETAIL



FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
OR
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2





NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

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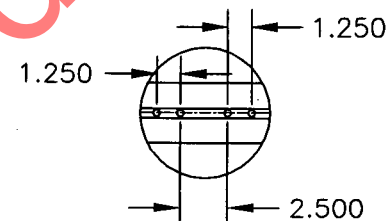
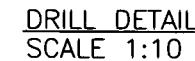
97/11/06 05

DART

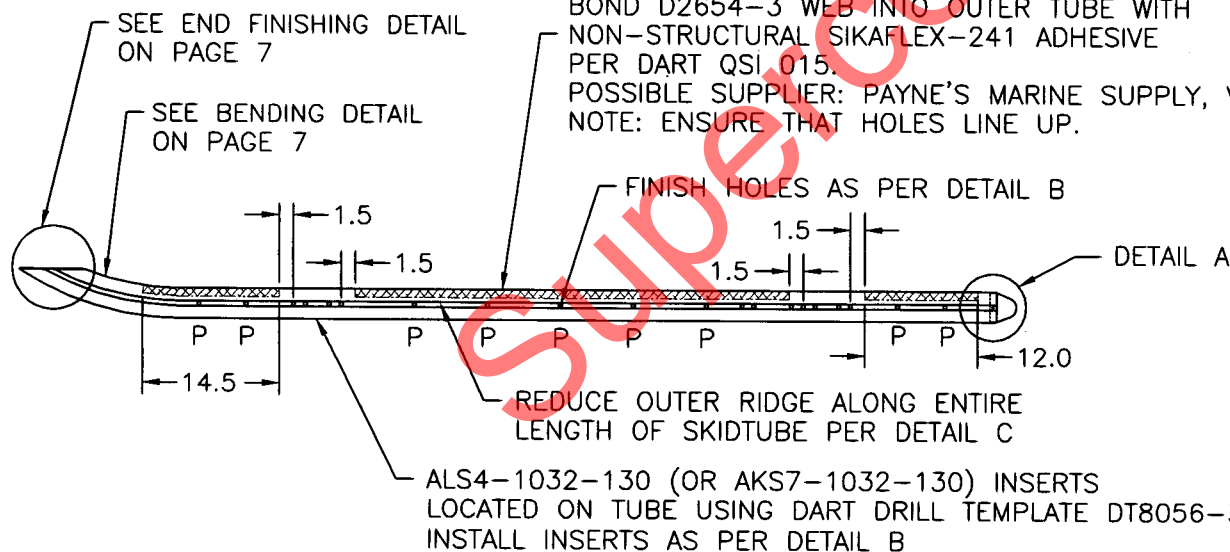


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CHECKED		APPROVED		DRAWING NO.	REV. C
				D2650	SHEET 2 OF 7
DATE				TITLE	SCALE
97.10.29				206/407 SKIDTUBE ASSEMBLIES	1:20

97/1106 DS



BOND D2654-3 WEB INTO OUTER TUBE WITH
NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
POSSIBLE SUPPLIER: PAYNE'S MARINE SUPPLY, VICTORIA
NOTE: ENSURE THAT HOLES LINE UP.



FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
OR
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2

NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

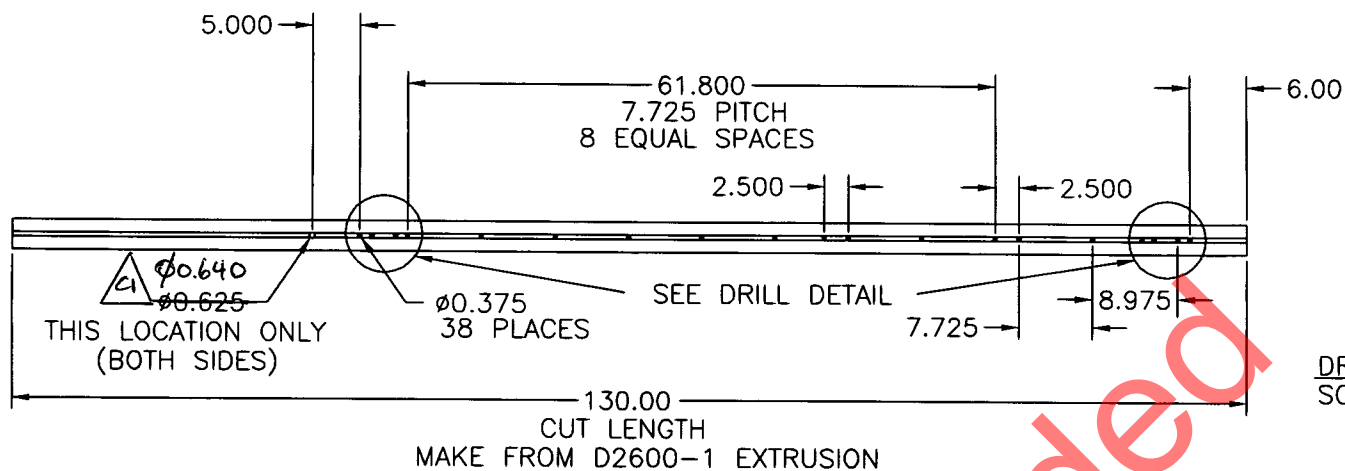
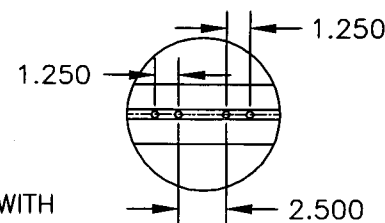
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DART

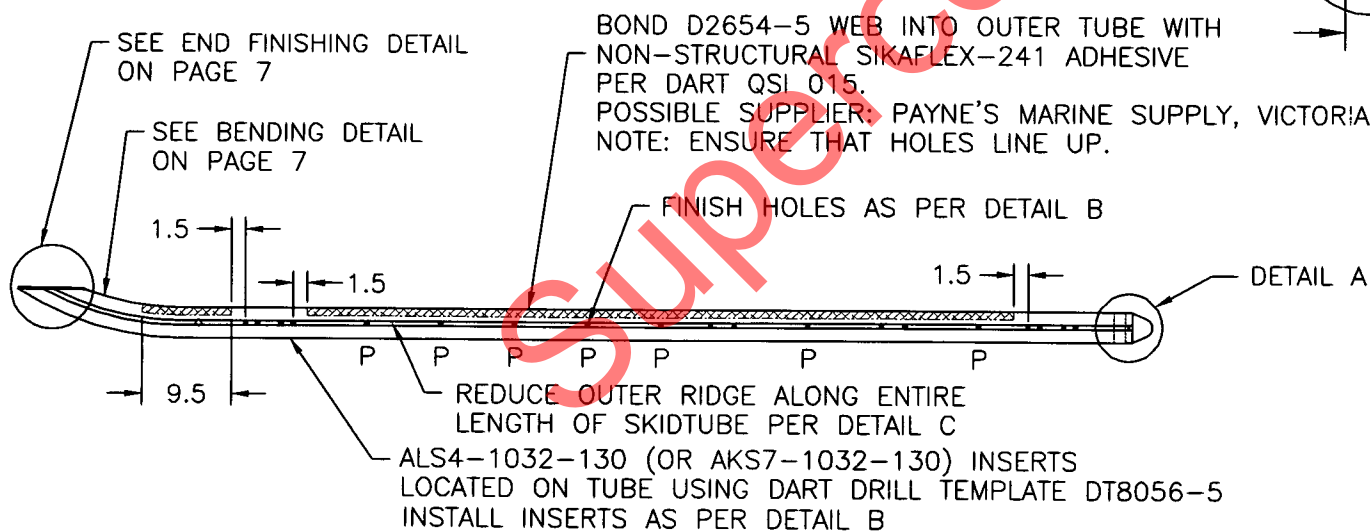


DESIGN <i>DM</i>	DRAWING BY <i>EE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	REV. C SHEET 3 OF 7
DATE 97.10.29	TITLE 206/407 SKIDTUBE ASSEMBLIES		SCALE 1:20

D2650-5 DRILLING DETAIL

DRILL DETAIL
SCALE 1:10

D2650-5 FINISHING DETAIL



FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
OR
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2

NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

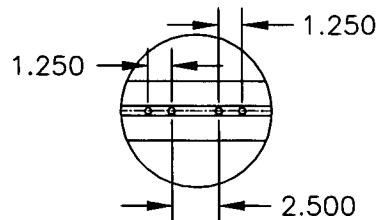
RELEASED
97/11/06 DS

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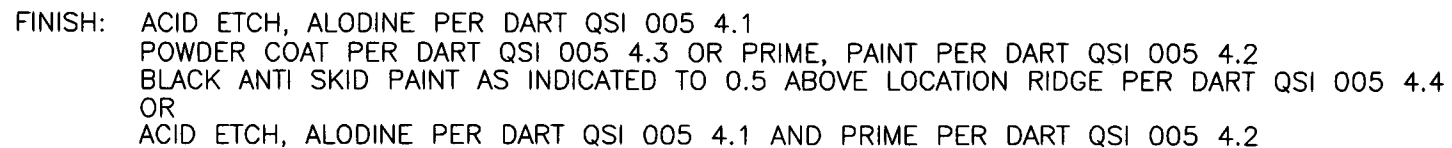


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DRAWING NO.	REV. C
97.10.29	D2650	SHEET 4 OF 7
	TITLE	SCALE
	206/407 SKIDTUBE ASSEMBLIES	1:20

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BOND D2654-7 WEB INTO OUTER TUBE WITH
- NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
POSSIBLE SUPPLIER: PAYNE'S MARINE SUPPLY, VICTORIA
NOTE: ENSURE THAT HOLES LINE UP.



DART



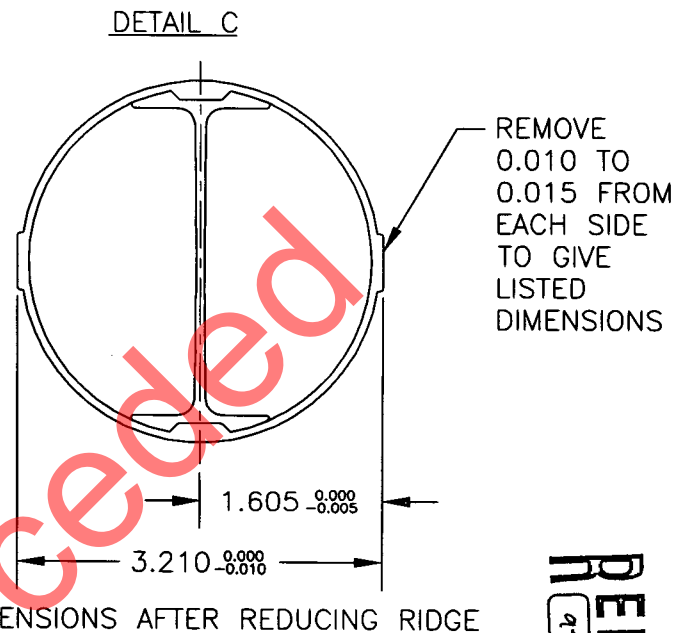
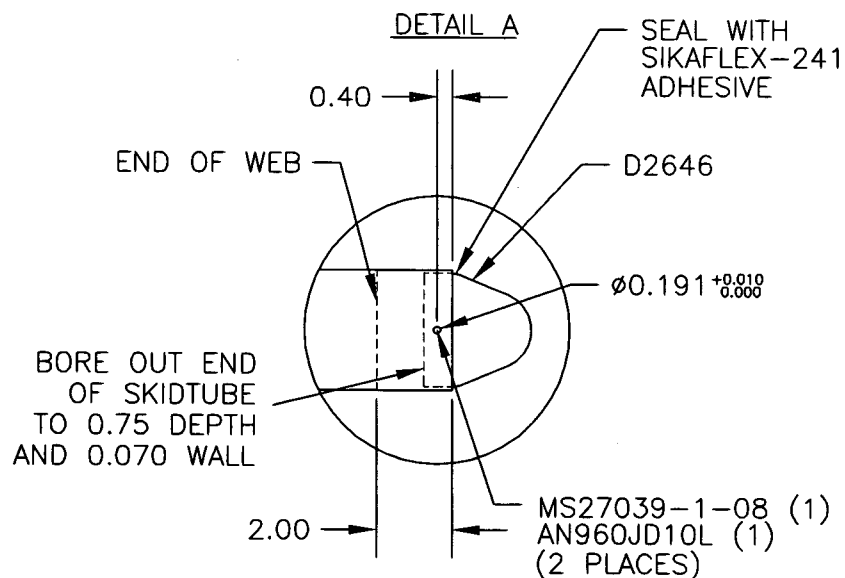
97 / u / v6 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
<i>DMJ</i>	<i>KE</i>	FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>DMJ</i>	<i>[Signature]</i>	D2650	SHEET 5 OF 7
DATE	TITLE		SCALE
97.10.29	206/407 SKIDTUBE ASSEMBLIES		1:20

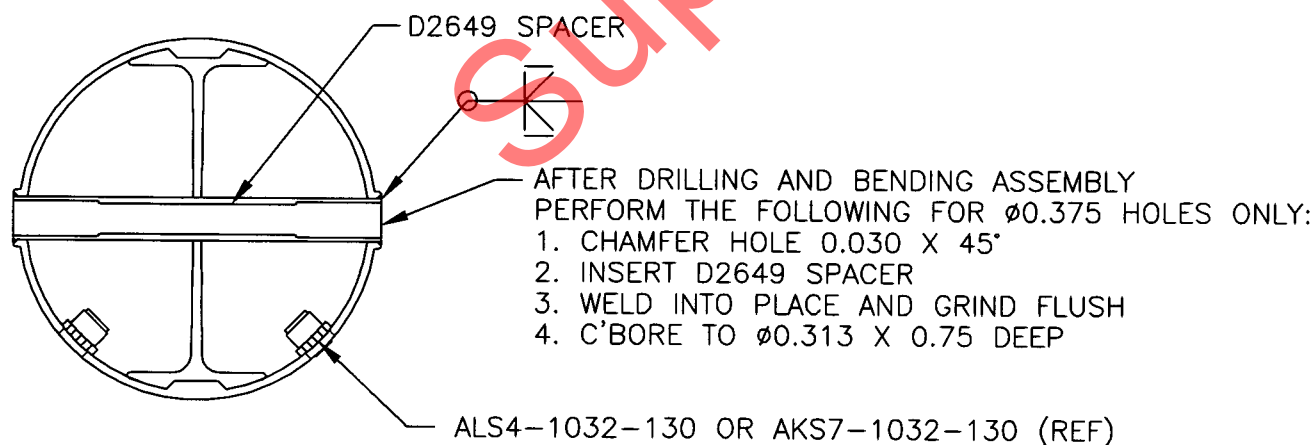


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DRAWING NO.	REV. C
97.10.29	D2650	SHEET 6 OF 7
	TITLE	SCALE
	206/407 SKIDTUBE ASSEMBLIES	NTS

RELEASED
97/10/29 DS



DETAIL B
FOR $\phi 0.375$ HOLES ONLY

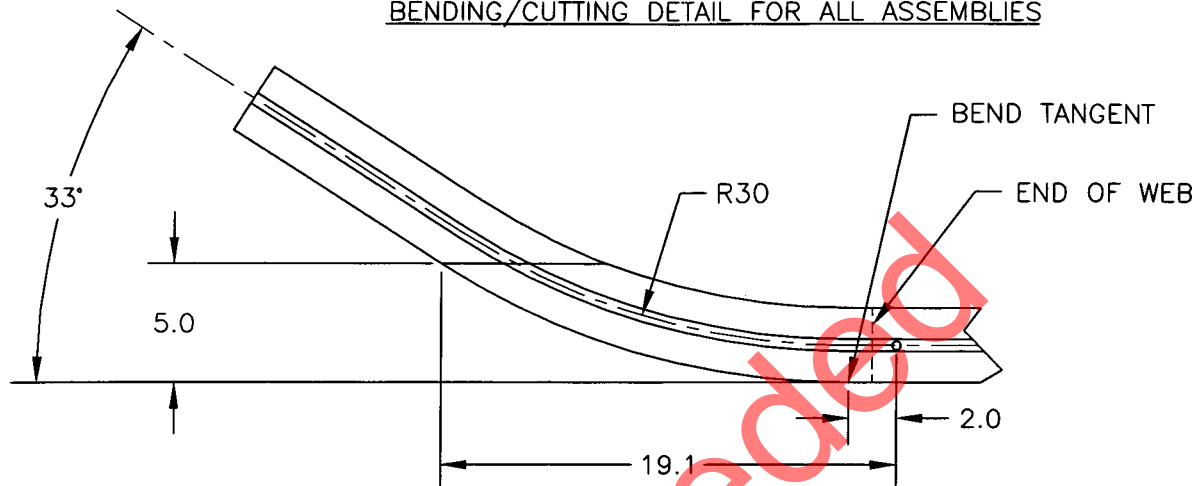




DESIGN <i>DMM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMM</i>	APPROVED <i>QJ</i>	DRAWING NO. D2650	REV. C SHEET 7 OF 7
DATE 97.10.29	TITLE 206/407 SKIDTUBE ASSEMBLIES		SCALE NTS

RELEASED
97/11/06 DS

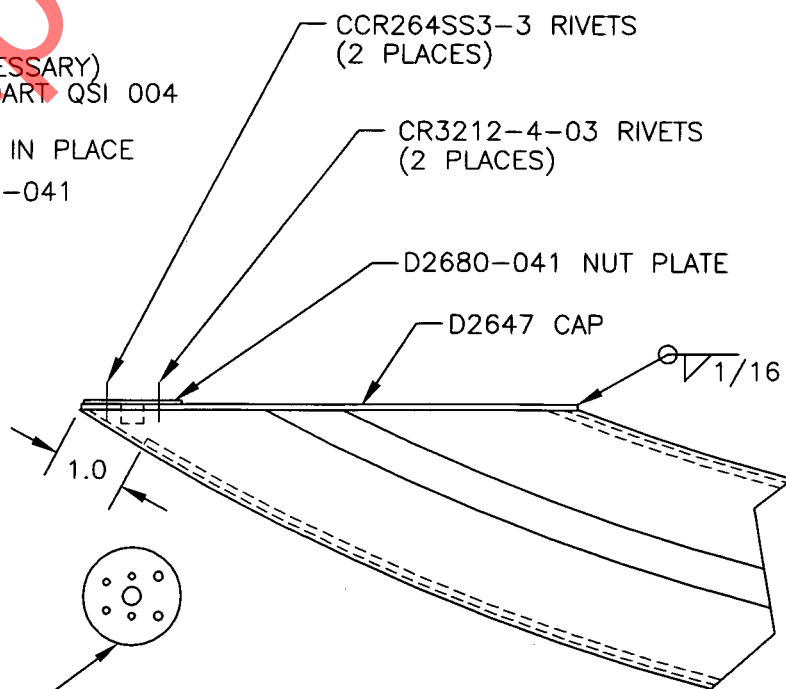
BENDING/CUTTING DETAIL FOR ALL ASSEMBLIES



END FINISHING DETAIL FOR ALL ASSEMBLIES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041
PRIOR TO FINISH



REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

ORIENTATION OF D2680-041



DESIGN <i>DIX</i>	DRAWN BY <i>DIX</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>CA</i>	DRAWING NO. DEO 9098	REV. A SHEET 1 OF 1
DATE 98.01.14		TITLE 206B GHW MODIFICATION	SCALE 1:3
A	98.01.14	NEW ISSUE	

RELEASED
98/01/28 DS

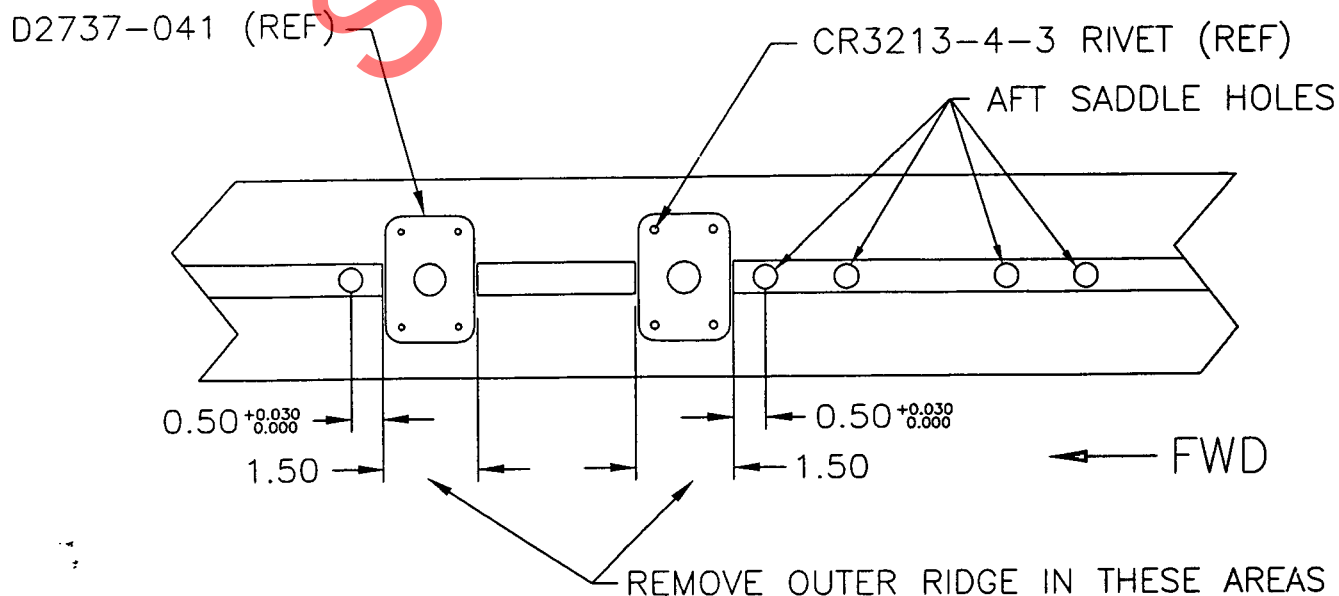
DART ENGINEERING ORDER

TO AMEND DRAWING D2650 REV. C
FOR D2650-1 AND D2650-3 ONLY

DO NOT WELD D2649 SPACERS IN THE 2 SETS OF HOLES
DIRECTLY IN FRONT OF THE AFT SADDLE HOLES. THESE HOLES
SHOULD BE FINISHED AS FOLLOWS:

- 1) DRILL HOLES TO $\phi 0.500$ (4 PLACES)
- 2) REMOVE OUTER RIDGE AS INDICATED TO LEAVE MAX
SKIDTUBE DIAMETER OF 3.150
- 3) LOCATE D2737-041 STUDS (4 REQ'D) IN PLACE, SEALING
COMPLETELY UNDERNEATH WITH SIKAFLEX 241
- 4) TRANSFER DRILL $\phi 0.125$ TO SKIDTUBE
- 5) INSTALL CR3213-4-3 RIVETS (16 REQ'D)

NOTE: STEPS 3), 4), AND 5) SHOULD BE COMPLETED AFTER
POWDER COAT.



DART

DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DM	APPROVED KE	DRAWING NO. DEO 9136	REV. A SHEET 1 OF 1
DATE 99.02.26	TITLE 206 SKIDTUBE WEB LENGTH CHANGE		SCALE NTS
A	99.02.26	NEW ISSUE	

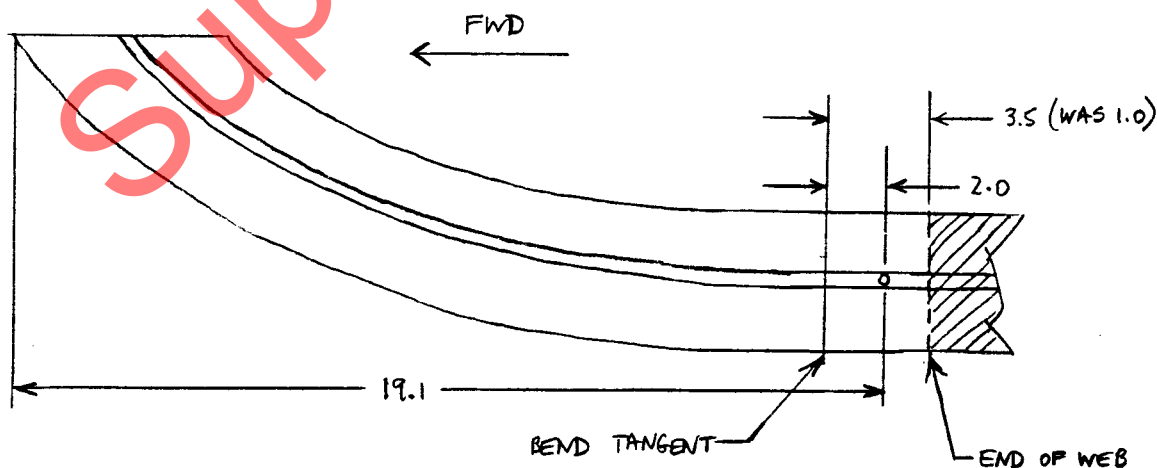
DART ENGINEERING ORDER

TO AMEND DWGS: D2650 REV. C
D2654 REV. D

TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

<u>PART NO.</u>	<u>LENGTH WAS</u>	<u>LENGTH NOW</u>
D2654-1	76.35	73.85
D2654-3	83.35	80.85
D2654-5	97.25	94.75
D2654-7	118.50	116.00

THE BENDING DETAIL ON PAGE 7 OF DWG D2650 WILL NOW BE AS FOLLOWS:



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION IN DIAMETER OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE.

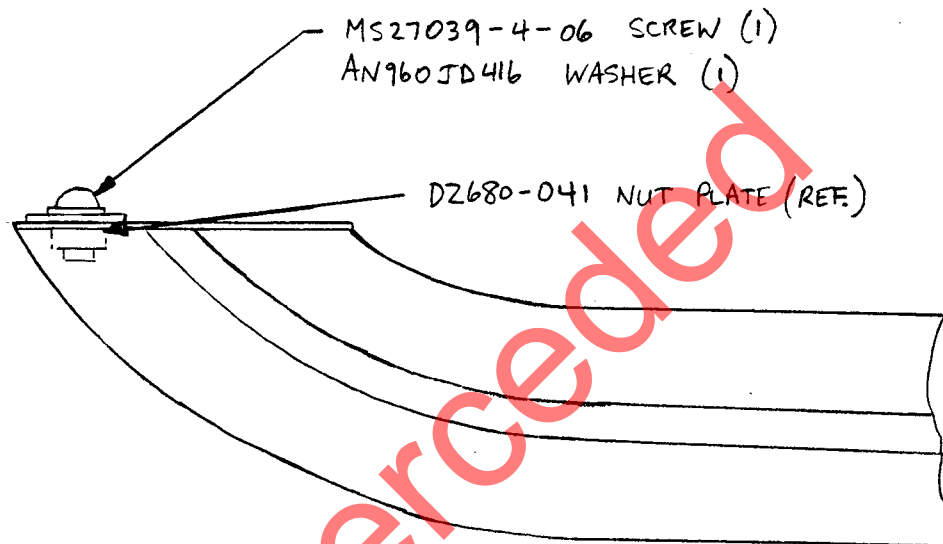
RELEASED
99.03.02 DS

DART

DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9153	REV. A SHEET 1 OF 1
DATE 99.04.26		TITLE 206 SKIDTUBE TOW RING BOLT	SCALE NTS
A	99.04.26	NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND DRAWING D2650 REV. C



INSTALL MS27039-4-06 SCREW IN D2680-041 NUT PLATE
LOCATED ON FWD END OF D2650-1/-3/-5/-7 SKIDTUBE ASSEMBLIES.
SEAL WITH SIKAFLEX 241/291 SEALANT.

NOTE: AN4-3A BOLT CAN BE SUBSTITUTED FOR MS27039-4-06 SCREW
IF MS27039-4-06 ARE UNAVAILABLE.

RELEASED
99.04.28 DS

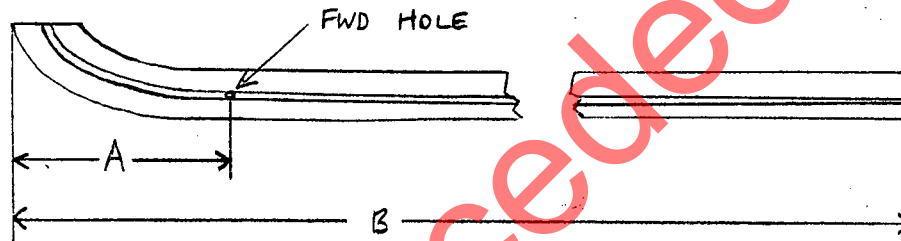
DART

DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. DEO 9163	REV. A SHEET 1 OF 1
DATE 99.09.16		TITLE D2650-3 LENGTH CHANGE	SCALE NTS
A	99.09.16	NEW ISSUE (REF. NCR 288)	

DART ENGINEERING ORDER

TO AMEND DWG D2650 REV. C

THE PURPOSE OF THIS ENGINEERING ORDER IS TO CLARIFY THE OVERALL LENGTH OF THE D2650 SKIDTUBES AND TO CORRECT THE LENGTH OF D2650-3 TO MATCH THE PARTS BEING MANUFACTURED.



<u>SKIDTUBE</u>	<u>ASSEMBLY</u>	<u>A</u>	<u>B</u>
D2650-1	D206-642-141	19.1	96.45
D2650-3	D206-642-241	20.1 (WAS 19.1)	104.45 (WAS 103.45)
D2650-5	D206-642-341	19.1	117.35
D2650-7	D206-642-441	19.1	138.60

RELEASED
99.09.16 DS